



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84288**

May-09-12 10:04:59 AM

**\*84288\***

Page 2

Item ID: D4027-043  
Revision ID:  
Item Name: Hose Clamp Assembly

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Start Date: 09/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00


**\*130\***

QC

Memo

0.00

Quality Control

12/6/18 ME  
12-06-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

May-09-12 10:05:03 AM

Page 1

Work Order ID: 84288

\*84288\*

Parent Item: D4027-043

\*D4027-043\*

Parent Item Name: Hose Clamp Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by:JLM IPP Rev:B  
10.05.17 as per ECN10-562 DD verf:EC IPP Rev:C 11.08.04  
was MS21042L09 is 06 (nut) DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4027-3 *D4027-3* Hose Clamp		Manufactured	No			100	Each	10.0000	1	4			
									**			(4) FF 12-06-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST450		10							
				80635		10				4			
D4027-7 *D4027-7* Rubber Cushion		Manufactured	No			100	Each	16.0000	1	4			
									**			(4) FF 12-06-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		16				4			
				67814		5				4			
				83970		11				3			
AN743-13 *AN743-13* BRACKET		Purchased	No			100	Each	5.0000	1	4			
									**			(4) FF 12-06-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		5				1			
				113706		5				3			
NAS1149DN632J *NAS1149DN632.I* Washer		Purchased	No			100	Each	338.0000	1	4			
									**			(4) FF 12-06-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST298		338							
				118428		338				4			

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 84288

Parent Item: D4027-043

Parent Item Name: Hose Clamp Assembly

**\*84288\***

**\*D4027-043\***

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

MS24693-S28

Purchased

No

100

Each

127.0000

1

4

**\*MS24693-S28\***

Screw

\*\*

(4) FF 12-06-14

Location

Loc Qty

Loc Code

ST288

127

11334

77

4824

9

8170

41

4

MS21042L06

Purchased

No

100

Each

372.0000

1

4

**\*MS21042L 06\***

Nut

\*\*

(4) FF 12-06-14

Location

Loc Qty

Loc Code

ST300

372

118354

2

119109

1

119758

1

120360

118

121444

150

121556

100

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

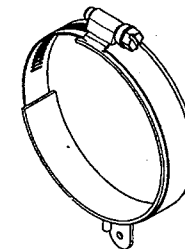
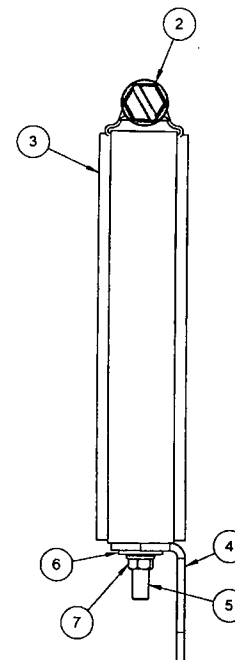
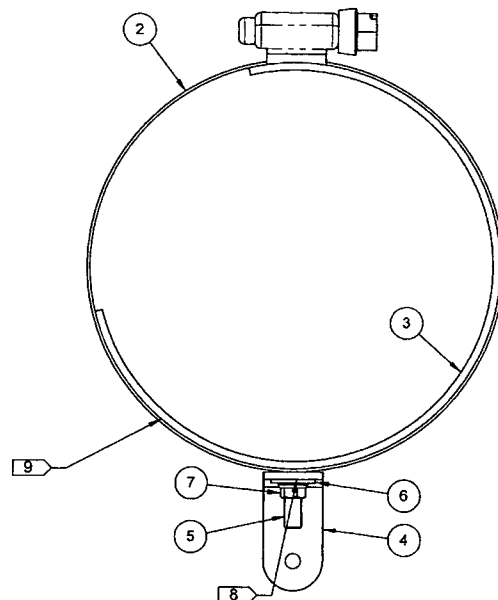
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-041	VENT CLAMP ASSEMBLY	JCA-M47-2-20
2	1	D4027-1	HOSE CLAMP	
3	1	D4027-5	RUBBER CUSHION	
4	1	D4027-9	BRACKET, SUPPORT ANGLE	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 84288 MJS  
12/05/09

RELEASED  
2010-05-05  
MD

**D4027-041 VENT CLAMP ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L06 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-5 RUBBER CUSHION TO D4027-1 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

A	NEW ISSUE		10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4027** REV. A  
SHEET 1 OF 7

TITLE **CLAMP** SCALE NTS

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

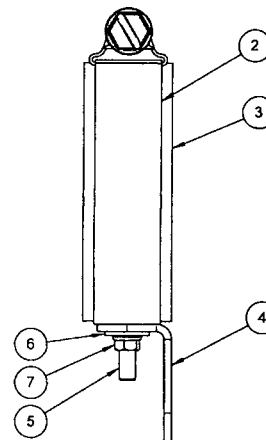
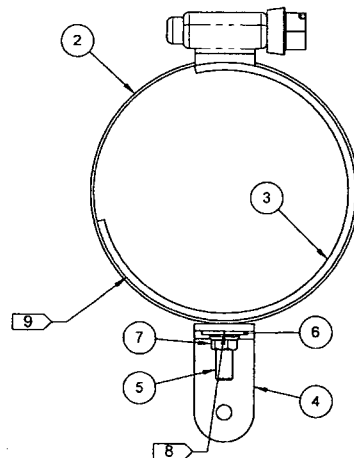
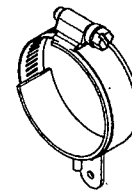
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4027-043	VENT CLAMP ASSEMBLY	JCA-M47-2-35
2	1	D4027-3	HOSE CLAMP	
3	1	D4027-25 <i>QSI018</i>	RUBBER CUSHION	
4	1	D4027-9 <i>QSI018</i>	BRACKET, SUPPORT CLAMP	
5	1	MS24693S28	SCREW	
6	1	NAS1149DN632J	WASHER	
7	1	MS21042L09	NUT	

24288



**D4027-043 VENT CLAMP ASSEMBLY**

**RELEASED**  
2010-05-05  
*NS*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) ATTACH D4027-9 BRACKET USING MS24693S28 SCREW, MS21042L09 NUT AND NAS1149DN632F WASHER
- 9) GLUE D4027-7 RUBBER CUSHION TO D4027-3 CLAMP USING 3M CONTACT CEMENT IN POSITION AS SHOWN

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4027	SHEET 2 OF 7
DE APPR.	<i>JS</i>	TITLE	SCALE
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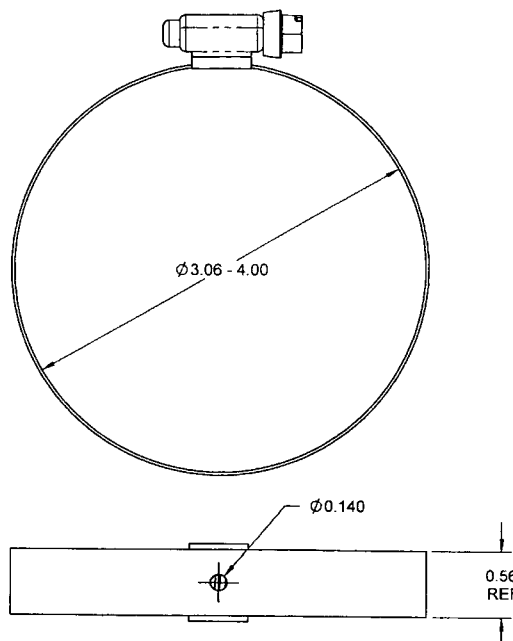
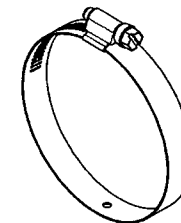
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-1	REF JCA-M47-2-20

84288



**D4027-1 HOSE CLAMP**

RELEASED  
2010-05-25

**NOTES:**

- 1) MATERIAL: MADE FROM QS200M56S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL  $\phi 0.140$  HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D4027	SHEET 3 OF 7
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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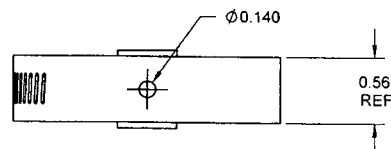
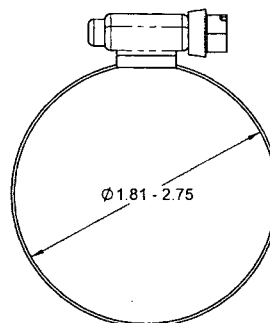
DART AEROSPACE  
PART NUMBER

D4027-3

JOHN CAMERON AVIATION  
PART NUMBER

REF JCA-M47-2-35

84288



**D4027-3 HOSE CLAMP**

RELEASED  
2010-05-05  
MD

**NOTES:**

- 1) MATERIAL: MADE FROM QS200M36S
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4027-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) DRILL Ø0.140 HOLE AS SHOWN OPPOSITE WORM DRIVE SCREW, DIMPLE HOLE FROM INSIDE FOR MS24693S28 SCREW

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED	APPROVED	DRAWING NO.	REV. A
MFG. APPR.	DE APPR.	D4027	SHEET 4 OF 7
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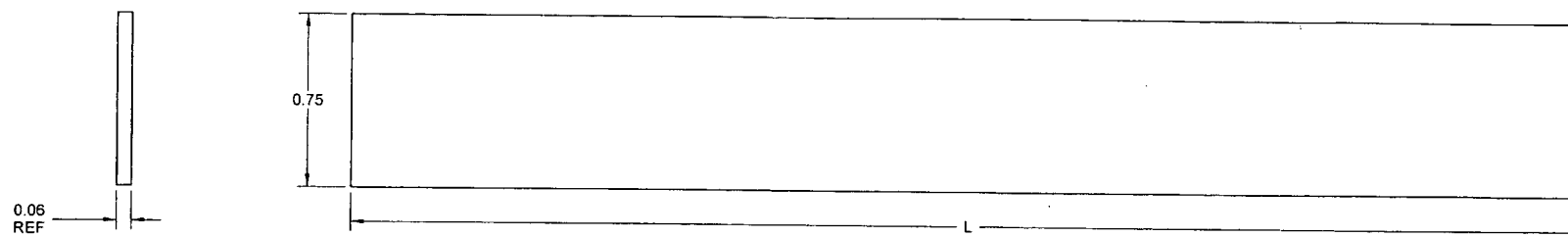
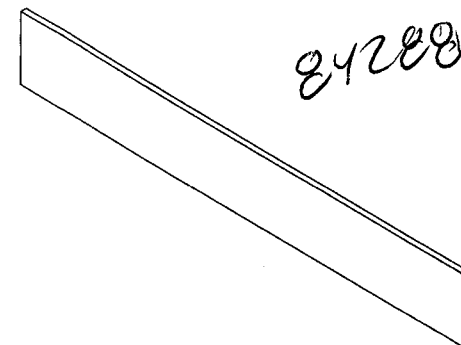
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4027-5	REF JCA-M47-2-20
D4027-7	REF JCA-M47-2-35



DART PART NUMBER	LENGTH "L"
D4027-5	5.30
D4027-7	8.25

**D4027-X RUBBER CUSHION**

**RELEASED**  
2010-05-05  
MD

**NOTES:**

- 1) MATERIAL: BLACK SOLID RUBBER NEOPRENE SHEET, 0.063 THICK  
REF DART SPEC M-NEO-60-S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D4027</b>
MFG. APPR.		REV. A
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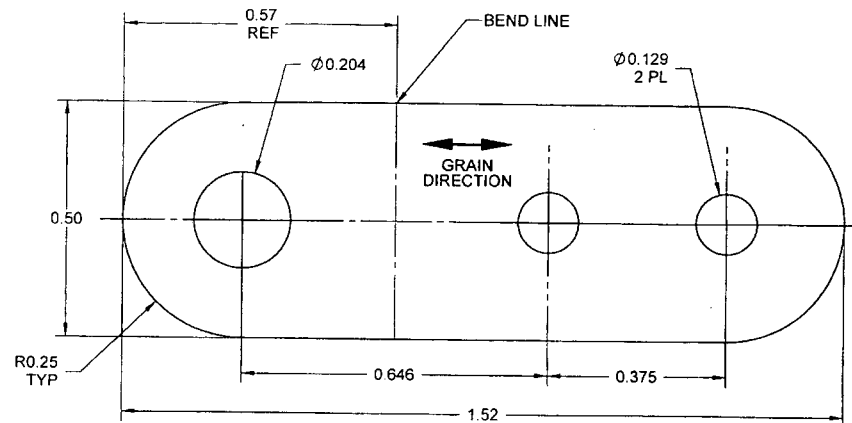
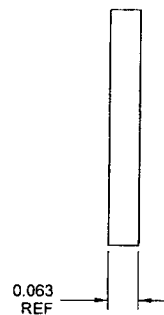
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**NOTE:** Date & initial all entries

84289









**D4027-9F FLAT PATTERN**

RELEASED  
2010-05-05  
ND

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 THICK  
PER AMS5513 (304) OR AMS 5524 (316)  
OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S16GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4027	SHEET 7 OF 7
APPROVED		TITLE	SCALE
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